



to overheat in vicinities of the tabs since only one tab is connected to each of the cathode and the anode. Therefore, since that is a bad influence on a load characteristic and a cycle lifetime characteristic (that is, a frequency of charge/discharge cycles of the secondary battery repeatedly used until a function of a secondary battery is over), a plurality of tabs are connected to each of the cathode and the anode and a current is collected from a plurality of points.

A large electrode-rolled battery such as this type, conventionally, as shown in Fig. 12, is provided with a rolled body 10 and a plurality of tabs (a tab 20, a tab 21, a tab 22, and a tab 23). The rolled body 10 is stored in a cylindrical case (not shown). The rolled body 10 is formed by rolling a band-shaped anode 11 and a band-shaped cathode 12 so as to put a separator 13 between them. The tab 20, the tab 21, the tab 22, and the tab 23 are respectively connected to four anode active material unformed parts 11a (after mentioned) in the anode 11. Similarly, other tabs (not shown) are connected to the cathode 12.

Fig. 13A and Fig. 13B show the anode 11 in Fig. 12, and Fig. 13A is a view showing a peripheral surface viewed from an arrow A in Fig. 12 and Fig. 13B is a plan unrolled view showing the anode 11.

As shown in Fig. 13A, in the rolled body 10, a central axis is set as "O", and a radius is set as "R" when the anode active material unformed parts of the cathode 11 exist in a peripheral surface of the rolled body 10. As shown in Fig. 13B, in the anode 11, the anode active material forming parts 11a ... the anode active material forming parts 11a are formed in a longitudinal direction of a band-shaped electrode 11p intermittently. The tab 20, the

tab 21, the tab 22, and the tab 23 are respectively connected to anode active material unformed parts 11b ... the anode active material unformed parts 11b between the anode active material forming parts 11a ... the anode active material forming parts 11a.

- 5 Each the anode active material unformed parts 11b is formed at regular intervals and has a regular length. A length L1 is set as follows:

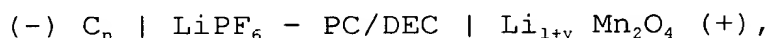
$$L1 < 2\pi R.$$

- 10 Further, the tab 20, the tab 21, the tab 22, and the tab 23 are connected to a same position of each the anode active material unformed parts 11b. The cathode 12 is formed similarly to the anode 11.

Figure 14 is a view showing an essential part of the rolled body 10 indicated by the arrow A in Fig. 12.

- 15 In the rolled body 10, as shown in Fig. 14, the anode 11 and the cathode 12 are rolled in a rolling direction S so that a separator (not shown) is put between the anode 11 and the cathode 12. To prevent  $\text{Li}^+$  ions in the anode active material from depositing as metallic lithium between the anode 11 and the
- 20 cathode 12, a deviation d1 is set between a start point of the anode active material unformed part 11b and a start point of a cathode active material unformed part 12b which is opposite to the anode active material unformed part 11b and a deviation d2 is set between an end point of the anode active material unformed
- 25 part 11b and an end point of the cathode active material unformed part 12b which is opposite to the anode active material unformed part 11b.

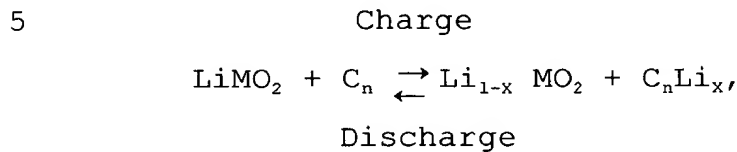
The electrode-rolled battery is represented by, for example,



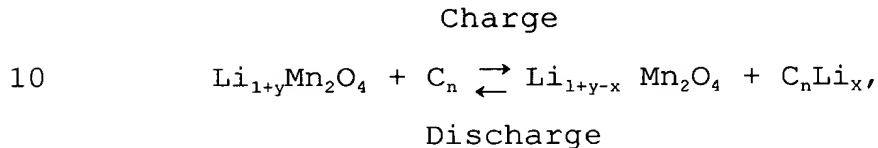
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where  $\text{LiPF}_6$  is lithium, PC is propylene carbonate (electrolyte) and DEC is diethyl carbonate (electrolyte).

A battery reaction is represented by:



or



where  $\text{LiMO}_2$  is lithium metallic oxide (anode active material), "M" is Co, Ni or Fe and " $\text{C}_n$ " is carbon material (cathode active material).

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Figure 15A to Fig. 22 are process diagrams for explaining a method of manufacturing the electrode-rolled battery shown in Fig. 12.

Manufacturing process (1) to manufacturing process (8) of the electrode-rolled battery shown in Fig. 12 will be explained with reference to Fig. 15A to Fig. 22.

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(1) Manufacturing process is shown in Fig. 15A and Fig. 15B.

As shown in Fig. 15A, an anode active material forming part 11a, an anode active material forming part 11a, ... an anode active material forming part 11a are intermittently provided on one side of the band-shaped electrode 11p in the longitudinal direction. Parts except the anode active material forming parts 11a are an anode active material unformed part 11b, an anode active material unformed part 11b, ... an anode active material unformed part 11b.

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A length of each anode active material unformed part 11b is set to length L1. Similarly, the anode active material forming part 11a, the anode active material forming part 11a, ... the anode active material forming part 11a are intermittently provided on another  
 5 side of the band-shaped electrode 11p in the longitudinal direction. As shown in Fig. 15B which is a sectional view of Fig. 15A taken along a line A-A of Fig. 15A, an anode 11 is manufactured in a manner that the anode active material forming part 11a, the anode active material forming part 11a, ... the anode active  
 10 material forming part 11a are formed on both sides of the band-shaped electrode 11p.

(2) Manufacturing process is shown in Fig. 16A and Fig. 16B.

As shown in Fig. 16A, a cathode material forming part 12a, a cathode active material forming part 12a, ... a cathode active  
 15 material forming part 12a are intermittently provided on one side of the band-shaped electrode 12p in the longitudinal direction. In this case, parts except the cathode active material forming parts 12a are a cathode active material unformed part 12b, a cathode active material unformed part 12b, ... a cathode active  
 20 material unformed part 12b. Similarly, the cathode active material forming part 12a, the cathode active material forming part 12a, ... the cathode active material forming part 12a are intermittently provided on another side of the band-shaped electrode 12p in the longitudinal direction. As shown in Fig. 16B  
 25 which is a sectional view of Fig. 16A taken along a line B-B, a cathode 12 is manufactured in a manner that the cathode active material forming part 12a, the cathode active material forming part 12a, ... the cathode active material forming part 12a are formed on both sides of the band-shaped electrode 12p.

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A tab 20, a tab 21, a tab 22, and a tab 23 are receptively connected to the anode active material unformed part 11b, the anode active material unformed part 11b, ... the anode active material unformed part 11b.

A tab 30, a tab 31, a tab 32, and a tab 33 are receptively connected to the cathode active material unformed part 12b, the cathode active material unformed part 12b ... the cathode active material unformed part 12b.

A separator 13 is put between the anode 11 and the cathode 12 and they are rolled by a rolling apparatus so as to manufacture the rolled body 10. Incidentally, the tab 30, the tab 31, the tab 32, and the tab 33 are not shown since they are pulled out from another side not a side from which the tab 20, the tab 21, the tab 22, and the tab 23 are pulled out.

The tab 20, the tab 21, the tab 22, and the tab 23 are gathered  
20 by a manual operation F of an operator. Similarly, the tab 30,  
the tab 31, the tab 32, and the tab 33 (not shown) are gathered.

A collecting header 24 is connected to the tab 20, the tab 21, the tab 22, and the tab 23 by manual operation of the operator, so as to perform ultrasonic welding. Similarly, a header (not shown) is connected to the tab 30, the tab 31, the tab 32, and the tab 33 (not shown). Then, the rolled body 10 is stored in a cylindrical case (not shown).

(8) Manufacturing process is shown in Fig. 22.

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battery.

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(1) Process is shown in Fig. 23A and Fig. 23B.

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end in the width direction. In this case, a part in addition to

the cathode active material forming parts 15a is a cathode active material unformed part 15b. Similarly, the cathode active material forming part 15a is continuously provided on another side of the band-shaped electrode 15p except one end in the width direction. As shown in Fig. 24B which is a sectional view of Fig. 24A taken along a line D-D, a cathode 15 is manufactured in a manner that the cathode active material forming part 15a and the cathode active material forming part 15a are formed on both sides of the band-shaped electrode 15p.

10 (3) Process is shown in Fig. 25.

The tab 20, the tab 21, the tab 22, and the tab 23 are connected to the anode active material unformed part 14b at regular intervals.

(4) Process is shown in Fig. 26.

15 The tab 30, the tab 31, the tab 32, and the tab 33 are connected to the cathode active material unformed part 15b at regular intervals. Then, same processes as shown in Fig. 19 to Fig. 22 are performed.

20 However, there are following problems in the above-mentioned electrode-rolled battery.

That is, since the length L1 of the anode active material unformed part 11b is shorter than  $2\pi R$ , it is impossible to arrange the tab 20, the tab 21, the tab 22, and the tab 23 regularly, for example, in a line. Therefore, there is a problem in that processes of gathering the tab 20, the tab 21, the tab 22, and the tab 23 and of connecting them to the header 24 (that is, processes shown in Fig. 20 and Fig. 21) are not only complicated but also it is difficult to perform these processes using an apparatus. Particularly, in a case in that the header 24 is ring-shaped or



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Further, the anode 14 shown in Fig. 25, areas for contacting the tab 20, the tab 21, the tab 22, and the tab 23 with the anode active material unformed part 14b are smaller than the anode 11 shown in Fig. 17. Therefore, there is a problem in that the internal impedance of the rolled body 10 is large. Also, there are many cases in that the anode 14 is in a wavy form caused by differences such expansions between the anode active material forming part 14a and the anode active material unformed part 14b during the manufacturing process, and therefore, there is a case in that the anode 14 is not suitable for use. Similarly, there is a case in that the cathode 15 shown in Fig. 26 is not suitable for use.

In view of the above, it is an object of the present invention  
20 to provide an electrode-rolled battery suitable to supply a  
large current and manufactured by a simple process and to provide  
a method of manufacturing the electrode-rolled battery.

According to a first aspect of the present invention, there is provided an electrode-rolled battery in which an anode and a cathode are rolled in a manner that a separator is put between the anode and the cathode and in which a plurality of collecting tabs is respectively provided with a plurality of cathode active material unformed parts and a plurality of anode active material forming parts; and

wherein when a length of an outermost anode active material unformed part is set as "L"; and when a distance from the outermost anode active material unformed part to a center of a rolled body made up of the anode, the cathode and the separator, is set as "R", a following expression is set:

$$L \geq 2\pi R.$$

According to a second aspect of the present invention, there is provided an electrode-rolled battery in which an anode and a cathode are rolled in a manner that a separator is put between the anode and the cathode and in which a plurality of collecting tabs is respectively provided with a plurality of cathode active material unformed parts and a plurality of anode active material forming parts; and

wherein when a length of an outermost anode active material unformed part is set as "L"; and when a distance from the outermost anode active material unformed part to a center of a rolled body made up of the anode, the cathode and the separator, is set as "R", when a deviation between a start point of the outermost anode active material unformed part and a start point of a outermost cathode active material forming part which is opposite to the outermost anode active material unformed part is set as " $\alpha$ ", and when a deviation between an end point of the outermost anode active material unformed part and an end point of the outermost cathode active material forming part which is opposite to the outermost anode active material unformed part is set as " $\beta$ ", a following expression is set:

$$L = 2\pi R + \alpha + \beta.$$

According to a third aspect of the present invention, there is provided an electrode-rolled battery comprising:

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an anode having a first band-shaped electrode and intermittently having anode active material forming parts on both sides of the first band-shaped electrode in a longitudinal direction;

5 a cathode having a second band-shaped electrode and intermittently having cathode active material forming parts on both sides of the first band-shaped electrode in a longitudinal direction;

10 a plurality of first collecting tabs formed in the anode active material forming parts of the first band-shaped electrode;

a plurality of second collecting tabs formed in the cathode active material unformed parts of the second band-shaped electrode; and

15 a separator put between the cathode and the anode; the electrode-rolled battery in which the anode, the cathode and the separator are rolled; and

wherein when a length of an outermost anode active material unformed part is set as "L"; and when a distance from the outermost anode active material unformed part to a center of a rolled body made up of the anode, the cathode and the separator, is set as "R", a following expression is set:

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$$L \geq 2\pi R.$$

According to a fourth aspect of the present invention, there is provided an electrode-rolled battery comprising:

25 an anode having a first band-shaped electrode and intermittently having anode active material forming parts on both sides of the first band-shaped electrode in a longitudinal direction;

a cathode having a second band-shaped electrode and

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a plurality of first collecting tabs formed in the anode  
5 active material forming parts of the anode;

a separator put between the cathode and the anode;

wherein when a length of an outermost anode active material unformed part is set as "L"; and when a distance from the outermost anode active material unformed part to a center of a rolled body made up of the anode, the cathode and the separator, is set as "R", when a deviation between a start point of the outermost anode active material unformed part and a start point of a outermost cathode active material forming part which is opposite to the outermost anode active material unformed part is set as " $\alpha$ ", and when a deviation between an end point of the outermost anode active material unformed part and an end point of the outermost cathode active material forming part which is opposite to the outermost anode active material unformed part is set as " $\beta$ ", a following expression is set:

25           In the foregoing, a preferable mode is one wherein each of  
the collecting tabs is arranged regularly on an end face of the  
rolled body.

According to a fifth aspect of the present invention, there is provided a method of manufacturing an electrode-rolled battery

5 plurality of anode active material forming parts; and

10 "R", a following expression is set:

$$L \geq 2\pi R.$$

15 separator is put between the anode and the cathode and in which  
a plurality of collecting tabs is respectively provided with a  
plurality of anode active material unformed parts and a plurality  
of cathode active material forming parts; and

unformed part is set as "L"; and when a distance from the outermost anode active material unformed part to a center of a rolled body made up of the anode, the cathode and the separator, is set as "R", when a deviation between a start point of the outermost anode active material unformed part and a start point of a outermost cathode active material forming part which is opposite to the outermost anode active material unformed part is set as " $\alpha$ ", and when a deviation between an end point of the outermost anode active material unformed part and an end point of the outermost cathode active material forming part which is opposite to the outermost

anode active material unformed part is set as " $\beta$ ", a following expression is set:

$$L = 2\pi R + \alpha + \beta.$$

According to a seventh aspect of the present invention, there  
5 is provided a method of manufacturing an electrode-rolled battery comprising:

an anode forming process of forming an anode by  
intermittently forming anode active material forming parts on  
both sides of a first band-shaped electrode in a longitudinal  
10 direction;

a cathode forming process of forming a cathode by  
intermittently forming cathode active material forming parts on  
both sides of a second band-shaped electrode in a longitudinal  
direction;

15 a connecting process of connecting a plurality of first  
collecting tabs to anode active material unformed parts of the  
first band-shaped electrode and of connecting a plurality of  
second collecting tabs to cathode active material unformed parts  
of the second band-shaped electrode;

20 a rolling process of rolling the cathode and the anode, and  
a separator which is put between the cathode and the anode;

a first tab gathering process of gathering each of the first  
collecting tabs;

a header connecting process of connecting a collecting  
25 header to the first collecting tabs which are gathered;

a second tab gathering process of gathering each of the  
second collecting tabs;

an electrolyte injecting process of injecting electrolyte  
into the rolled body using an electrolyte injecting apparatus:

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wherein when a length of an outermost anode active material unformed part is set as "L"; and when a distance from the outermost anode active material unformed part to a center of a rolled body made up of the anode, the cathode and the separator, is set as

5 "R", a following expression is set:

$$L \geq 2\pi R.$$

According to an eighth aspect of the present invention, there is provided a method of manufacturing an electrode-rolled battery comprising:

10 an anode forming process of forming an anode by intermittently forming anode active material forming parts on both sides of a first band-shaped electrode in a longitudinal direction;

15 a cathode forming process of forming a cathode by intermittently forming cathode active material forming parts on both sides of a second band-shaped electrode in a longitudinal direction;

20 a connecting process of connecting a plurality of first collecting tabs to anode active material unformed parts of the first band-shaped electrode and of connecting a plurality of second collecting tabs to cathode active material unformed parts of the second band-shaped electrode;

a rolling process of rolling the cathode and the anode, and a separator which is put between the cathode and the anode;

25 a first tab gathering process of gathering each of the first collecting tabs;

a header connecting process of connecting a collecting header to the first collecting tabs which are gathered;

a second tab gathering process of gathering each of the

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second collecting tabs;

an electrolyte injecting process of injecting electrolyte into the rolled body using an electrolyte injecting apparatus; and

5 wherein when a length of an outermost anode active material unformed part is set as "L"; and when a distance from the outermost anode active material unformed part to a center of a rolled body made up of the anode, the cathode and the separator, is set as "R", when a deviation between a start point of the outermost anode  
10 active material unformed part and a start point of a outermost cathode active material forming part which is opposite to the outermost anode active material unformed part is set as " $\alpha$ ", and when a deviation between an end point of the outermost anode active material unformed part and an end point of the outermost cathode  
15 active material forming part which is opposite to the outermost anode active material unformed part is set as " $\beta$ ", a following expression is set:

$$L = 2\pi R + \alpha + \beta.$$

In the foregoing, a preferable mode is one wherein each of  
20 the collecting tabs is arranged regularly on an end face of the rolled body.

According to the present invention, since a length L of the outermost anode active material unformed part is set as follows:

$$L \geq 2\pi R \text{ (for example, } L = 2\pi R + \alpha + \beta),$$

25 the first collecting tabs can be arranged regularly, for example, the first collecting tabs are pulled in a line in a diameter direction of the rolled body or are equally dispersed on the circumference of the rolled body. Therefore, the process of gathering the first collecting tabs (first tab gathering process)

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and the process of connecting gathered first collecting tabs to the header (header connecting process) are made simple when compared with a conventional technique. Further, since the first collecting tabs can be arranged regularly, in the process of injecting electrolyte to the rolled body in the electrolyte injecting process, an electrolyte injecting nozzle apparatus is easily inserted, and therefore, the operation is made easier than the conventional technique.

Further, since it is possible to set the first collecting tabs at any position, it is possible to set an internal impedance of the rolled body small. Therefore, though a large current is continuously supplied from the electrode-rolled battery to a load, there is no case in that the rolled body heats and the electrolyte degrades, and therefore, a cycle lifetime characteristic of the electrode-rolled battery improves in comparison with a conventional electrode-rolled battery. Also, it is possible to set the first collecting tabs freely, and therefore, though in the anode, the anode active material forming parts are positioned so that the first collecting tabs are pulled in a line in the diameter direction of the rolled body, it is possible to manufacture the electrode-rolled battery based on an original design without influences of parameters such as thickness accuracy of the anode, thickness accuracy of the cathode, and rolling force of the rolling apparatus, to obtain a desired characteristic and to manufacture electrode-rolled batteries without characteristic deviations.

#### BRIEF DESCRIPTION OF THE DRAWINGS

The above and other objects, advantages, and features of the present invention will be more apparent from the following description taken in conjunction with the accompanying drawings in which:

5        Fig. 1 is a perspective view showing an electrode-rolled battery according to an embodiment of the present invention;

      Fig. 2A and Fig. 2B are views showing an anode 41 shown in Fig. 1;

10       Fig. 3 is a view showing an essential part of a rolled body 40 indicated by an arrow A shown in Fig. 1;

      Fig. 4A and Fig. 4B are views showing a process of manufacturing the anode 41;

      Fig. 5A and Fig. 5B are views showing a process of manufacturing a cathode;

15       Fig. 6 is a view showing a process of connecting tabs;

      Fig. 7 is another view showing a process of connecting tabs;

      Fig. 8 is a view showing a process of rolling;

      Fig. 9 is a view showing a process of gathering first tabs;

      Fig. 10 is a view showing a process of connecting a header;

20       Fig. 11 is a view showing a process of injecting electrolyte;

      Fig. 12 is a perspective view showing a conventional electrode-rolled battery;

25       Fig. 13A and Fig. 13B are views showing an anode 11 shown in Fig. 12;

      Fig. 14 is a view showing an essential part of a rolled body 10 indicated by an arrow A shown in Fig. 12;

      Fig. 15A and Fig. 15B are views showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

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Fig. 16A and Fig. 16B are views showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

Fig. 17 is a view showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

5        Fig. 18 is another view showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

Fig. 19 is another view showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

10       Fig. 20 is another view showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

Fig. 21 is another view showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

Fig. 22 is yet still another view showing a process of manufacturing the electrode-rolled battery shown in Fig. 12;

15       Fig. 23A and Fig. 23B are views showing a process of manufacturing another conventional electrode-rolled battery;

Fig. 24A and Fig. 24B are views showing a process of manufacturing the conventional electrode-rolled battery shown in Fig. 23A and 23B;

20       Fig. 25 is another view showing a process of manufacturing the conventional electrode-rolled battery shown in Fig. 23A and 23B; and

25       Fig. 26 is yet still another view showing a process of manufacturing the conventional electrode-rolled battery shown in Fig. 23A and 23B.

#### DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Best modes for carrying out the present invention will be

described in further detail using an embodiment with reference to the accompanying drawings.

Figure 1 is a perspective view showing an electrode-rolled battery according to an embodiment of the present invention.

5       The electrode-rolled battery according to this embodiment, as shown in Fig. 1, is provided with a rolled body 40 and a plurality of tabs (a tab 50, a tab 51, a tab 52, and a tab 53). The rolled body 40 is stored in a cylindrical case (not shown). The rolled body 40 is made by rolling a band-shaped anode 41  
10       (hereinafter may also be referred to as anode 41) and a band-shaped cathode 42 (hereinafter may also be referred to as-cathode 42) so that a separator 43 is put between the band-shaped anode 41 and the band-shaped cathode 42. The tab 50, the tab 51, the tab 52, and the tab 53 are respectively connected to four  
15       anode active material unformed parts in the anode 41. Similarly, a plurality of tabs (not shown) is connected to the cathode 42.

Figure 2A and Fig. 2B are views showing the anode 41 shown in Fig. 1. Figure 2A is a view showing a periphery of the rolled body 40 indicated from an arrow A in Fig. 1 and Fig.2B is a plan  
20       unfolded view showing the anode 41.

The rolled body 40 is not precisely cylindrical in fact and is a distorted cylinder. Since the anode 41, the cathode 42, and the separator 43 are thin (for example, the anode 41 and the cathode 42 are between several-tens of microns and several-  
25       hundreds of microns and the separator 43 is several-tens of microns), it is possible to approach a precise cylinder. Thus, the anode 41, the cathode 42, and the separator 43 are rolled using a central axis "O" as a start point so as to form the rolled body 40. As shown in Fig. 2A, a maximum value "R" of a radius

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of the rolled body 40 is set in a case anode active material  
 unformed parts of the anode 41 appear on the periphery. Further,  
 as shown in Fig. 2B, in the anode 41, an anode active material  
 forming part 41a, an anode active material forming part 41a, ...  
 5 an anode active material forming part 41a are intermittently  
 formed in a longitudinal direction of a band-shaped electrode  
 41p. The tab 50, the tab 51, the tab 52, and the tab 53 are  
 respectively connected to an anode active material unformed part  
 41b, an anode active material unformed part 41b, ... an anode active  
 10 material unformed part 41b between the anode active material  
 forming part 41a, the anode active material forming part 41a,  
 ... the anode active material forming part 41a. Respectively the  
 anode active material unformed parts 41b are formed at regular  
 intervals and have a same length "L2". Also, the tab 50, the tab  
 15 51, the tab 52, and the tab 53 are respectively connected to same  
 positions of the anode active material unformed parts 41b. The  
 cathode 42 is formed approximately similarly to a conventional  
 cathode 12 shown in Fig. 16.

Figure 3 is a view showing an essential part of the rolled  
 20 body 40 indicated by the arrow A shown in Fig. 1.

In the rolled body 40, as shown in Fig. 3, the anode 41 and  
 the cathode 42 are rolled in a rolling direction "S" so that the  
 separator 43 (not shown) is put between the anode 41 and the  
 cathode 42. Further, a deviation " $\alpha$ " is set between a start point  
 25 of the anode active material unformed part 41b and a start point  
 of a cathode active material unformed part 42b which is opposite  
 to the anode active material unformed part 41b, and a deviation  
 " $\beta$ " is set between an end point of a anode active material unformed  
 part 41b and an end point of the cathode active material unformed

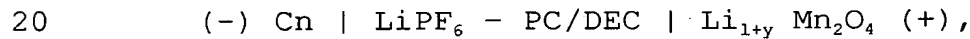
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part 42b which is opposite to the anode active material unformed part 41b. Thus, the length "L2" of each anode active material unformed part 41b is set as follows:

$$L2 \geq 2\pi R \text{ (for example, } L2 = 2\pi R + \alpha + \beta),$$

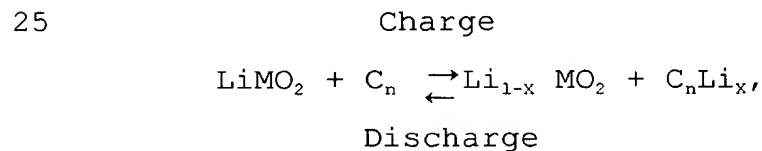
- 5 Where a distance from an outermost anode active material unformed part 41b to a center of the rolled body 40 made up of the anode 41, the cathode 42 and the separator 43, is set as "R", and where the deviation " $\alpha$ " and the deviation " $\beta$ " are set 5 mm to 7 mm when the diameter ( $=2R$ ) of the rolled body 40, for example, is 33 mm.
- 10 In a lithium ion secondary battery, when there is no anode active material a cathode surface which is opposite to the anode active material via the separator,  $\text{Li}^+$  ion deposits as metal lithium on the electrode surface of the cathode, and therefore, the deviation " $\alpha$ " and the deviation " $\beta$ " are margins set to prevent
- 15 metal lithium from depositing.

In a case of the lithium ion secondary battery, the electrode-rolled battery is represented by, similarly to the conventional electrode-rolled battery shown in Fig. 12, for example,



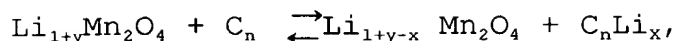
where  $\text{LiPF}_6$  is fluophosphoric lithium, PC is propylene carbonate (electrolyte) and DEC is diethyl carbonate (electrolyte).

A battery reaction is represented by:



or

## Charge



## Discharge

5 where  $\text{LiMO}_2$  is lithium metallic oxide (anode active material),  
 "M" is Co, Ni or Fe and " $\text{C}_n$ " is carbon material (cathode active  
 material).

Figure 4A to Fig. 10 are process diagrams for explaining  
 a method of manufacturing the electrode-rolled battery shown in  
 10 Fig. 1.

Manufacturing process (1) to manufacturing process (8) of  
 the electrode-rolled battery shown in Fig. 1 will be explained  
 with reference to Fig. 4A to Fig. 10.

(1) Process is shown in Fig. 4A and Fig. 4B (Anode  
 15 manufacturing process).

As shown in Fig. 4A, an anode active material forming part  
 41a, an anode active material forming part 41a, ... an anode active  
 material forming part 41a are intermittently provided on one side  
 of the band-shaped electrode 41p in the longitudinal direction.  
 20 In this case, anode active material is made in paste and is coated  
 on the band-shaped electrode 41p. Parts in addition to the anode  
 active material forming parts 41a, are the anode active material  
 unformed part 41b, the anode active material unformed part 41b,  
 ... the anode active material unformed part 41b. A length of each  
 25 anode active material unformed part 41b is set to "L2". Similarly,  
 the anode active material forming part 41a, the anode active  
 material forming part 41a, ... the anode active material forming  
 part 41a are intermittently provided on another side of the  
 band-shaped electrode 41p in the longitudinal direction. As shown



in Fig. 4B which is a sectional view of Fig. 4A taken along a line E-E, an anode 41 is manufactured in a manner that the anode active material forming part 41a, the anode active material forming part 41a, ... the anode active material forming part 41a are formed on both sides of the band-shaped electrode 41p.

(2) Process is shown in Fig. 5A and Fig. 5B (Cathode manufacturing process).

As shown in Fig. 5A, a cathode active material forming part 42a, a cathode active material forming part 42a, ... a cathode active material forming part 42a are intermittently provided on one side of the band-shaped electrode 42p in the longitudinal direction. In this case, anode active material is made in paste and is coated on the band-shaped electrode 41p. Parts in addition to the cathode active material forming parts 42a are a cathode active material unformed part 42b, a cathode active material unformed part 42b, ... a cathode active material unformed part 42b. Similarly, the cathode active material forming part 42a, the cathode active material forming part 42a, ... the cathode active material forming part 42a are intermittently provided on another side of the band-shaped electrode 42p in the longitudinal direction. As shown in Fig. 5B which is a sectional view of Fig. 5A taken along a line F-F, an anode 42 is manufactured in a manner that the cathode active material forming part 42a, the cathode active material forming part 42a, ... the cathode active material forming part 42a are formed on both sides of the band-shaped electrode 42p.

(3) Process is shown in Fig. 6 (Tab connecting process).

The tab 50, the tab 51, the tab 52, and the tab 53 are respectively connected to the anode active material unformed part 41b, the anode active material unformed part 41b, ... the anode

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The tab 50, the tab 51, the tab 52, and the tab 53 are gathered by an operation F such as a tab gathering apparatus. Similarly, the tab 60, the tab 61, the tab 62, and the tab 63 (not shown) are gathered.



As described above, according to this embodiment, since the length "L2" of the anode active material unformed part 41b is set as follows:

$$L \geq 2\pi R \text{ (for example, } L = 2\pi R + \alpha + \beta),$$

5 the tab 50, the tab 51, the tab 52, and the tab 53 are arranged regularly, for example, the tab 50, the tab 51, the tab 52, and the tab 53 are pulled in a line in a diameter direction of the rolled body 40 or are equally dispersed on the circumference of the rolled body 40. Therefore, the process of gathering the tab  
10 50, the tab 51, the tab 52, and the tab 53 (first tab gathering process) and the process of connecting the tab 50, the tab 51, the tab 52, and the tab 53 to the header 54 (header connecting process) are performed by apparatuses and are made simple compared with the conventional technique. Further, in the process of  
15 injecting electrolyte to the rolled body 40 (electrolyte injecting process), the electrolyte injecting nozzle N is easily inserted, and therefore, the operation is easier than the conventional technique.

Further, since it is possible to set the tab 50, the tab  
20 51, the tab 52, and the tab 53 at any position, it is possible to set an internal impedance of the rolled body 40 small. Therefore, though a large current is continuously supplied from the electrode-rolled battery to a load, there is no case in that the rolled body 40 heats and the electrolyte degrades, and therefore,  
25 the cycle lifetime characteristic of the electrode-rolled battery improves in comparison with the conventional electrode-rolled battery. Also, it is possible to set the tab 50, the tab 51, the tab 52, and the tab 53 freely, and therefore, though in the anode 41, the anode active material forming parts 41a are positioned

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so that the tab 50, the tab 51, the 52, and the tab 53 are pulled in a line in the diameter direction of the rolled body 40, it is possible to manufacture an electrode-rolled battery based on an original design without influences of parameters such as the thickness accuracy of the anode 41, the thickness accuracy of the cathode 42 or the rolling force of the rolling apparatus.

It is thus apparent that the present invention is not limited to the above embodiments but may be changed and modified without departing from the scope and spirit of the invention.

For example, manufacturing the anode active material forming part 41a is not limited to coating active material, and any technique such as burning or spattering if only the cathode active material forming part 41a is formed.

Also, when the tab 50, the tab 51, the tab 52 and the tab 53 are connected to the anode active material unformed part 41b, the anode active material unformed part 41b, ... the anode active material unformed part 41b and when the collecting header 54 is connected to the tab 50, the tab 51, the tab 52, and the tab 53 by any technique such as resistance welding and caulking in addition to ultrasonic welding.

Also, in the first tab gathering process, the tab 50, the tab 51, the tab 52, and the tab 53 may be gathered by a manual operation of an operator. In this case, since the tab 50, the tab 51, the tab 52, and the tab 53 are arranged regularly, the gathering operation can be easily compared with the conventional process.

Also, in this embodiment, the outermost anode active material unformed part 41b of the anode 41 is provided on the most-peripheral surface of the rolled body 40, to the contrary, when the outermost cathode active material unformed part 42b of

the cathode 42 is provided on the most-peripheral surface of the rolled body 40, this invention is applied to the outermost anode active material unformed part 41b in an inside of the most-peripheral surface of the rolled body 40.

- 5        Furthermore, this invention is available for all electrode-rolled batteries, and not limited only to lithium ion secondary batteries.

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